

# Work Order ID 84005

May-01-12 10:39:54 AM

Page 1

SHIP FROM JUNE 15 \*84005\*

Item ID: D3043-042

Revision ID:

Item Name: Step Weldment RH, A119

Start Date: 01/05/2012 Start Qty: 4.00

Required Date: 15/05/2012 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: ME5

Date: 12/05/01

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3043	Rev A

100

\*100\*

Large Fab

Large Fab

Large Fab

Memo

1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G  
2-Deburr and bevel ends for welding

0.00

0.00

4

0

Ae

12.05.30

110

\*110\*

QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

4

0

AE

12.06.05

120

\*120\*

Large Fab

Large Fab

Large Fab

Memo

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8808  
AR AL ROD Batch: 120854  
2-Grind Fwd End Cap weld flush

0.00

0.00

4

0

AE

12.06.06

Ae

12.06.11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84005

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May-01-12 10:39:54 AM

Item ID: D3043-042 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Step Weldment RH, A119  
 Start Date: 01/05/2012 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 15/05/2012 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				4	0	8E12/06/12	
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				4			
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				4		76126-12	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 84005

\*84005\*

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May-01-12 10:39:54 AM

Item ID: D3043-042  
Revision ID:  
Item Name: Step Weldment RH, A119

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Start Date: 01/05/2012 Start Qty: 4.00  
Required Date: 15/05/2012 Req'd Qty: 4.00

\*4\*  
\*4\*

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab	Large Fab	0.00				4	0		12.06.12
Large Fab	Memo 1-1-Weld 1 End Cap as per QSI 004 & Dwg AR AL ROD Batch: 120354 2-Inspect for foreign object as per QSI 024 3-Grind Fwd End Cap weld flush	0.00							12.06.13
170 *170* QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00							
180 *180* QC	QC5- Inspect part completeness to step on W/O	0.00				24			
Quality Control	Memo	0.00				RH			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84005

\*84005\*

Page 4

May-01-12 10:39:54 AM

Item ID: D3043-042

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Step Weldment RH, A119

Start Date: 01/05/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Touch up alodine

0.00

\*190\*

HandFinish

Memo

0.00

Hand Finishing

4 76 12-6-14

210

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*210\*

Powdercoat

Memo

0.00

Powder Coating

START Time:

OVEN TEMPERATURE:

FINISH TIME:

8-30 3200F  
9-00 121613

4X 12/06/15

220

Wing Walk as per dwg QSI005 4.4 Batch

0.00

\*220\*

HandFinish

Memo

0.00

Hand Finishing

4 12-6-15

M121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 84005

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May-01-12 10:39:54 AM

Item ID: D3043-042  
Revision ID:  
Item Name: Step Weldment RH, A119

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Start Date: 01/05/2012 Start Qty: 4.00  
Required Date: 15/05/2012 Req'd Qty: 4.00

\*4\*

\*4\*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC3- Inspect Part Finish	0.00							
*230*									
QC	Memo	0.00							
Quality Control									
240	Identify as per dwg & Stock Location: _____	0.00							
*240*									
Packaging	Memo	0.00							
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00							
*250*									
QC	Memo	0.00							
Quality Control									

9/28/15 (4)

12/6/15

12/6/18

W 12/6-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-01-12 10:39:58 AM

Page 1

Work Order ID: 84005

\*84005\*

Parent Item: D3043-042

\*D3043-042\*

Parent Item Name: Step Weldment RH, A119

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue JLM 05-11-01

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

100

Each

109.7300

1

4

\*D2622-120C\*

Step Extrusion

\*\*

B83894 ④ A2 12.05.30

Location

Loc Qty

Loc Code

HALL

16.37

46910

2

64409

6

66970

7.7

68293

0.25

72131

0.42

WA

84

81507

84

WA013

9.36

75781

2

77612

7.36

D2734

Manufactured

No

120

Each

53.0000

1

4

\*D2734\*

Step End Plate

\*\*

12.05.05

Location

Loc Qty

Loc Code

WA

53

76985

25

80682

28

4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-01-12 10:39:58 AM

Page 2

Work Order ID: 84005

\*84005\*

Parent Item: D3043-042

\*D3043-042\*

Parent Item Name: Step Weldment RH, A119

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 4.00

Required Qty: 4.00

D3040-1 Manufactured No

120 Each

41.0000 2 8

\*D3040-1\*

Mounting Lug

\*\*

*12.06.05*

Location

Loc Qty

Loc Code

WA

41

77683

10

79722

10

80808

21

D3040-3 Manufactured No

120 Each

21.0000 2 8

\*D3040-3\*

Mounting Lug

\*\*

*12.06.05*

Location

Loc Qty

Loc Code

WA018

21

76998

21

D2734 Manufactured No

160 Each

53.0000 1 4

\*D2734\*

Step End Plate

\*\*

*12.06.12*

Location

Loc Qty

Loc Code

WA

53

76985

25

80682

28

May-01-12 10:39:58 AM

Shop Packet Print

Page 2

W/O:			WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3043	REV. A SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

**PARTS LIST:**

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

**NOTES:**

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP  
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
01.07.05 *[Signature]*

12/05/01  
NO. 24005 MLC  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
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SHOP COPY

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

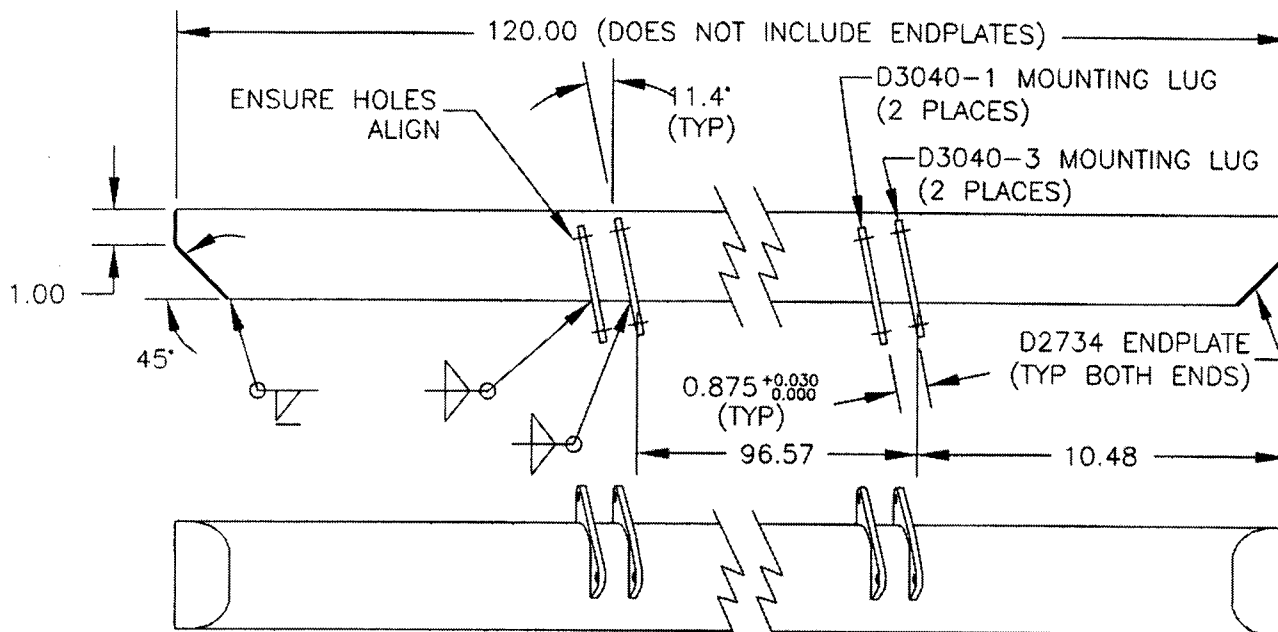
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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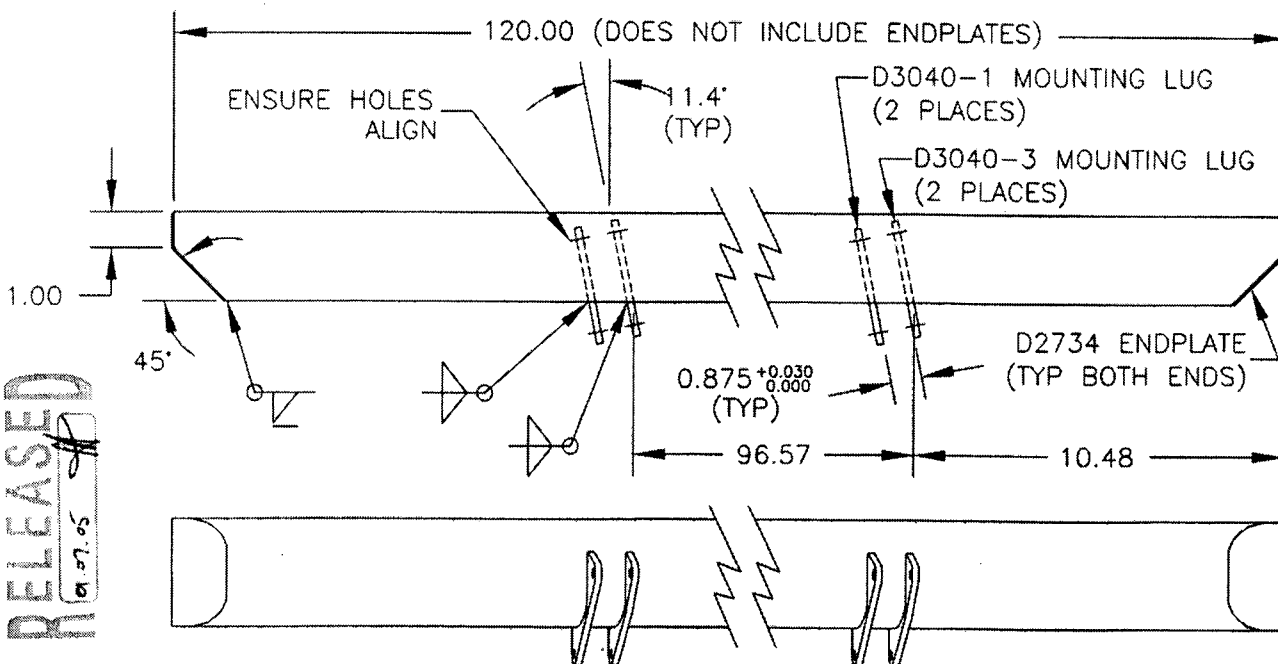




DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

RELEASED  
19 07.05

24008

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries